

Work Order ID 105405

105405

Page 1

August-01-13 11:30:30 AM

Item ID: D412-761-047 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Instrument Panel
 Start Date: 8/01/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 8/01/13 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 13-08-01 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-761	E								
100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPP D412-761-047	CHG002							
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
31
9-89

DAS
26
9-89

IX 13-11-29

8/3/12/30

Q

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
☐ Bending	☐ Bend	☐ Grain
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear
☐ Cuffs	☐ Contamination	☐ Maintenance
☐ Heat Treat	☐ Countersink	☐ Misabeled
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread
☐ Ripples in Bend	☐ Drill Holes	☐ Offset
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration
☐ Turning Sequence	☐ Finish	☐ Out of Sequence
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions
		☐ Ovalized
		☐ Over/Under tolerance
		☐ Part Incorrect
		☐ Part Lost/Missing
		☐ Part Moved
		☐ Positioned Wrong
		☐ Power Loss/Surge
		☐ Pressure/Forced
		☐ Temperature/Cure
		☐ Weld
		☐ Wrong Stock Pulled
		☐ Other

Work Order ID 105405

105405

Page 2

August-01-13 11:30:30 AM

Item ID: D412-761-047

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Instrument Panel

Start Date: 8/01/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 8/01/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	Packaging	0.00				1	8	13-12-30	
-----	-----------	------	--	--	--	---	---	----------	--

130

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D412-761-047

Location: ~~PG-03~~ 031A

PPP Rev: C

140	QC21- Final Inspection - Work Order Release	0.00							
-----	---	------	--	--	--	--	--	--	--

140

QC

Quality Control

Memo

0.00

MF 13-12-30

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
☐ Bending	☐ Bend	☐ Grain
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear
☐ Cuffs	☐ Contamination	☐ Maintenance
☐ Heat Treat	☐ Countersink	☐ Misabeled
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread
☐ Ripples in Bend	☐ Drill Holes	☐ Offset
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration
☐ Turning Sequence	☐ Finish	☐ Out of Sequence
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions
		☐ Ovalized
		☐ Over/Under tolerance
		☐ Part Incorrect
		☐ Part Lost/Missing
		☐ Part Moved
		☐ Positioned Wrong
		☐ Power Loss/Surge
		☐ Pressure/Forced
		☐ Temperature/Cure
		☐ Weld
		☐ Wrong Stock Pulled
		☐ Other

Picklist Print

August-01-13 11:30:29 AM

Page 1/5

Work Order ID: 105405

Parent Item: D412-761-047

Parent Item Name: Instrument Panel

Start Date: 8/01/13

Required Date: 8/01/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 09-01-13 rev.C as per dwg DD verified by:EC IPP Rev:B 13.01.15 as per ECN13-511 DD Verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN34A Bolt		Purchased	No			110	Each	565.0000	4	4			DAS 26 9-89
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST350		124							
				120308		80							
				122814		38							
				124858		6							
				ST512		441							
				120770		35							
				123900		1							
				125445		405							
D3705-11 MAIN PANEL		Manufactured	No			110	Each	2.0000	1	1			DAS 26 9-89
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST063		2							
				101786		2							
D3705-7 Main Panel		Manufactured	No			110	Each	1.0000	1	1			DAS 26 9-89
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST063		1							
				96156		1							
D3705-9 PANEL		Manufactured	No			110	Each	5.0000	1	1			DAS 26 9-89
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST063		5							
				103490		5							

DAS
31
9-89

DAS
26
9-89

DAS
31
9-89

DAS
26
9-89

DAS
31
9-89

DAS
26
9-89

DAS
31
9-89

2X

B103765

B103483

13-11-29

1X

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric to O/S ☐ Cracks ☐ Crushed/Crimped ☐ Cuffs ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Ripples in Bend ☐ Torque Waves in Extrusion ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damaged ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drill Holes ☐ Drawing ☐ Finish ☐ Folio	☐ Grain ☐ Hardware ☐ Inspection Incomplete ☐ Instructions Incomplete/Unclear ☐ Maintenance ☐ Mislabeled ☐ Misread ☐ Offset ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions
		☐ Ovalized ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Picklist Print

August-01-13 11:30:29 AM

Page 2

Work Order ID: 105405
Parent Item: D412-761-047
Parent Item Name: Instrument Panel

Start Date: 8/01/13

Required Date: 8/01/13

Start Qty: 1.00

Required Qty: 1.00

D4758-1
Blanking Plate

Manufactured No

110 Each 12.0000

2 2

DAS
26
9-89

Location

Loc Qty

Loc Code

ST122

12

DAS
31
9-89

98103

12

Manufactured No

110 Each 2.0000

3 3

DAS
26
9-89

Location

Loc Qty

Loc Code

ST122

2

DAS
31
9-89

97162

2

Purchased No

110 Each 2,925.0000

10 10

DAS
26
9-89

Location

Loc Qty

Loc Code

ST293

37

DAS
31
9-89

125268

37

ST294

2888

122973

106

125044

290

m125807

2492

Manufactured No

110 Each 0.0000

1 1

DAS
32
9-89

Manufactured No

110 Each 14.0000

2 2

DAS
26
9-89

Location

Loc Qty

Loc Code

ST063

14

DAS
31
9-89

103447

2

103729

12

Manufactured No

110 Each 1.0000

1 1

DAS
26
9-89

Location

Loc Qty

Loc Code

ST064

1

96147

1

DAS
31
9-89

D3705-041
INSTRUMENT PANEY ASSY
D3707-1
Mounting Lug

D3790-1
Indexing Block

Shop Packet Print

August-01-13 11:30:30 AM

Page 2

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General	Other	Other
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	☐ Pressure/Forced
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	☐ Temperature/Cure
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	☐ Weld
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions	☐ Wrong Stock Pulled
			☐ Other

Picklist Print

August-01-13 11:30:30 AM

Page 3

Work Order ID: 105405
Parent Item: D412-761-047
Parent Item Name: Instrument Panel

Start Date: 8/01/13

Required Date: 8/01/13

Start Qty: 1.00

Required Qty: 1.00

D38671
Connector Plate
AN526G1032R6
Screw

Manufactured No
Purchased No

110 Each 0.0000
110 Each 629.0000

① B103733
② 6
DAS 26 9-89
DAS 26 9-89

Location Loc Qty Loc Code

ST346 629
1892 629
Purchased No
110 Each 14.0000

② 6x
② MID7124
DAS 26 9-89

Location Loc Qty Loc Code

ST343 10
M126175 10
ST347 4
100798 4

DAS 31 9-89

MS21075L3
Nut Plate

Purchased No

110 Each 771.0000

② 6
② 6
DAS 26 9-89

Location Loc Qty Loc Code

ST318 5
123832 5
st507 766
125646 766

DAS 31 9-89

MS24693-C272
Screw

Purchased No

110 Each 1,166.0000

② 4x
② 4
13-11-29
DAS 26 9-89

Location Loc Qty Loc Code

ST300 1166
17137 467
17831 519
9370 180

② 4x
② 4
DAS 26 9-89

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
☐ Bending	☐ Bend	☐ Grain
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware
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☐ Cuffs	☐ Contamination	☐ Maintenance
☐ Heat Treat	☐ Countersink	☐ Mislabeled
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread
☐ Ripples in Bend	☐ Drill Holes	☐ Offset
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration
☐ Turning Sequence	☐ Finish	☐ Out of Sequence
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions
		☐ Ovalized
		☐ Over/Under tolerance
		☐ Part Incorrect
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		☐ Part Moved
		☐ Positioned Wrong
		☐ Power Loss/Surge
		☐ Pressure/Forced
		☐ Temperature/Cure
		☐ Weld
		☐ Wrong Stock Pulled
		☐ Other

Picklist Print

August-01-13 11:30:30 AM

Page 4

Work Order ID: 105405
Parent Item: D412-761-047
Parent Item Name: Instrument Panel

Start Date: 8/01/13

Required Date: 8/01/13

Start Qty: 1.00

Required Qty: 1.00

DAS
26
9-89

MS27039-1-17
Screw (601.1954)

Purchased No

110 Each 212.0000

1

Location

Loc Qty

Loc Code

GA
120142
ST506
124326

48
48
164
164

110 Each 54.0000

1

DAS
26
9-89

MS27039-1-27
Screw

Purchased No

Location

Loc Qty

Loc Code

ST306
110606

54
54

110 Each 7,537.0000

4

DAS
26
9-89

MS21042L3
Nut

Purchased No

Location

Loc Qty

Loc Code

FP001
122141
GA
122452
ST314
111668
117885
119017
119075
123265
M126036
ST506
123900
124291
ST510a
M126275
M126333

3
3
18
18
980
1
32
55
138
43
711
1536
912
624
5000
1000
4000

DAS
26
9-89

DAS
31
9-89

13-11-29

4A

August-01-13 11:30:30 AM

Shop Packet Print

Page 4

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data ☐											
Equip/Tooling ☐											
Operator ☐											
Material ☐											
Setup ☐											
Other ☐											
Process ☐											
Supplier ☐											
Training ☐											
Unapproved ☐											
FAULT CATEGORY											
Landing Gear ☐ Bending ☐ Centre Not Concentric to O/S ☐ Cracks ☐ Crushed/Crimped ☐ Cuffs ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Ripples in Bend ☐ Torque Waves in Extrusion ☐ Turning Sequence ☐ Wave/Twist in Tube			General ☐ Bend ☐ BOM/Route ☐ Broken/Damaged ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drill Holes ☐ Drawing ☐ Finish ☐ Folio			☐ Grain ☐ Hardware ☐ Inspection Incomplete ☐ Instructions Incomplete/Unclear ☐ Maintenance ☐ Mislabeled ☐ Misread ☐ Offset ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions			☐ Ovalized ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other		

Picklist Print

August-01-13 11:30:30 AM

Page 5

Work Order ID: 105405

Parent Item: D412-761-047

Parent Item Name: Instrument Panel

Start Date: 8/01/13

Required Date: 8/01/13

Start Qty: 1.00

Required Qty: 1.00

MS21919-WDG8

Purchased

No

110

Each

28.0000

Clamp

DAS
26
9-89

m/27305
13-11-29

Location

Loc Qty

Loc Code

ST322

28

123900

8

125445

20

DAS
26
9-89

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data ☐											
Equip/Tooling ☐											
Operator ☐											
Material ☐											
Setup ☐											
Other ☐											
Process ☐											
Supplier ☐											
Training ☐											
Unapproved ☐											

FAULT CATEGORY											
Landing Gear ☐ Bending ☐ Centre Not Concentric to O/S ☐ Cracks ☐ Crushed/Crimped ☐ Cuffs ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Ripples in Bend ☐ Torque Waves in Extrusion ☐ Turning Sequence ☐ Wave/Twist in Tube			General ☐ Bend ☐ BOM/Route ☐ Broken/Damaged ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drill Holes ☐ Drawing ☐ Finish ☐ Folio			☐ Grain ☐ Hardware ☐ Inspection Incomplete ☐ Instructions Incomplete/Unclear ☐ Maintenance ☐ Mislabeled ☐ Misread ☐ Offset ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions			☐ Ovalized ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other		

2/13/12/30

6.0 PARTS LIST, FULL VERTICAL REFERENCE DOOR MOD KITS

QTY -041	QTY -041A	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -141	PART NUMBER	DESCRIPTION
								D412-761-011	FULL VERTICAL REFERENCE DOOR, LH
								D412-761-011A	FULL VERTICAL REFERENCE DOOR, LH
X								D412-761-041	FULL VERTICAL REFERENCE DOOR KIT, LH
	X							D412-761-041A	FULL VERTICAL REFERENCE DOOR KIT, LH
		X	1					D412-761-043	MODIFIED LATCH MECHANISM KIT, LH
1	1		X					D412-761-045	LARGE BUBBLE WINDOW KIT, LH
1	1			X				D412-761-047	DOOR MOUNTED INSTRUMENT PANEL KIT, LH
1					X			D412-761-049	ARMREST KIT, LH
	1					X		D412-761-051	ARMREST KIT, LH
							X	D412-761-141	VENT KIT
		1						D3589-041	LATCH ASSEMBLY
		1						D3589-047	FORWARD GUIDE
		1						D3589-049	AFT GUIDE
		2						MS16997-24	SCREW
		2						MS21042L06	NUT
		2						NAS1149DN632J	WASHER (OR AN960JD6L)
		1						D3676-1	LARGE BUBBLE WINDOW
		1						D3678-1	PLACARD
		1						D3678-3	PLACARD
		1						D3700-1	INBOARD WINDOW DOUBLER
		1						D3700-3	OUTBOARD WINDOW DOUBLER
		1						D3701-1	FLOOR DOUBLER
		1						D3702-1	FORWARD DOUBLER
		1						D3703-1	AFT DOUBLER
		1						D3703-3	AFT CORNER DOUBLER
		1						D3703-5	AFT CAP
		1						D3704-1	ESCUTCHEON
		1						D3704-3	ESCUTCHEON
		1						D3708-1	ANGLE
		1						D3708-3	ANGLE
		1						D3709-1	ANGLE
		1						D3709-3	ANGLE
		1						D3802-1-135	SEAL
		1						DT9458	CUTTING TEMPLATE
		26						AN3-7A	BOLT
		26						MS21042L3	NUT
		1						MS24694-C5	SCREW (OR MS24694-S5)
		1						MS24694-C13	SCREW (OR MS24694-S13)
		1						NAS43DD3-24	SPACER
		52						NAS1149D0363J	WASHER (OR AN960JD10)

(CONTINUED ON PAGE 11)

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Date: 12.12.07

(CONTINUED FROM PAGE 10)

QTY -041	QTY -041A	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -141	PART NUMBER	DESCRIPTION
				1				D3705-041	INSTRUMENT PANEL ASSEMBLY
				1				D3705-043	* INSTRUMENT PANEL WELDMENT
				1				D3335-1	* SPRING
				1				D3705-5	* ACCESS PANEL
				1				D3706-041	* LOCK BRACKET ASSEMBLY
				1				D3706-5	* PIN
				2				D3707-3	* MOUNTING LUG
				2				AN3-3A	* BOLT
				4				AN526C1032R6	* SCREW
				1				MS171498	* SPRING SLOTTED PIN
				4				MS24693-C272	* SCREW (OR MS24693-S272)
				2				NAS1149D0332J	* WASHER (OR AN960JD10L)
				1				NAS1149D0563J	* WASHER (OR AN960JD516)
				1				D3705-7	FACE PLATE (MINIMUM REQUIRED INSTRUMENTS FOR 204, 205, 210, AND EAGLE SINGLE MODELS)
				1				D3705-9	FACE PLATE (MINIMUM REQUIRED AND OPTIONAL INSTRUMENTS FOR 204, 205, 210, AND EAGLE SINGLE MODELS)
				1				D3705-11	FACE PLATE (FOR 212, 214, 412, MODELS)
				2				D3707-1	MOUNTING LUG
				1				D3790-1	INDEXING BLOCK
				1				D3867-17	CONNECTOR PLATE
				2				D4758-1	BLANKING PLATE
				3				D4758-3	BLANKING PLATE
				4				AN3-4A	BOLT
				6				AN526C1032R6	SCREW
				2				AN743-12	BRACKET
				6				AN960JD10L	WASHER
				6				MS21075L3	NUTPLATE (OR MS21073-3)
				4				MS24693-C272	SCREW (OR MS24693-S272)
				1				MS27039-1-17	SCREW
				1				MS27039-1-27	SCREW
				4				MS21042L3	NUT
				2				MS21919WDG8	CLAMP
				4				NAS1149D0332J	WASHER (OR AN960JD10L)
					1	1		D3694-041	MOUNTING PLATE ASSEMBLY
					1	1		D3694-1	* KEYWAY
					1	1		D3694-3	* PROTECTIVE PLATE
					1	1		D3694-5	* MOUNTING PLATE
					1	1		AN526C1032R8	* SCREW
					4	4		MS21042L3	* NUT
					2	2		MS21209F1-20	* HELI-COIL, SCREW LOCKING (RED)
					1	1		MS24693-C271	* SCREW (OR MS24693-S271)
					4	4		MS24693-C273	* SCREW (OR MS24693-S273)
					5	5		NAS1149D0363J	* WASHER (OR AN960JD10)
								D3695-041	SLIDER ASSEMBLY
					1	1		D3695-1	* SLIDER
					1	1		D3695-3	* STOPPER
					1	1		MS21209F6-25	* HELI-COIL, SCREW LOCKING (RED)
					4	4		MS21209F1-20	* HELI-COIL, SCREW LOCKING (RED)
					4	4		MS24693-C276	* SCREW (OR MS24693-S276)
					1	1		D3801-1	* HAND RETRACTABLE SPRING PLUNGER

*DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

(CONTINUED ON PAGE 12)

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Date: 12.12.07

(CONTINUED FROM PAGE 11)

QTY -041	QTY -041A	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -141	PART NUMBER	DESCRIPTION
					1			D3780-041	ARMREST ASSEMBLY
					1			D3696-041	* ARM ASSEMBLY
					1			D3696-1	** ARM
					1			D3801-3	** HAND RETRACTABLE SPRING PLUNGER
					1			D3781-041	* LATERAL CUSHION ASSEMBLY
					1			D3781-043	* ARMREST CUSHION ASSEMBLY
					1			D3785-3	* BRACKET
					1			D3977-1	* BOLT
					1			D3978-1	* NUT (CASTELLATED)
					1			D3979-1	* WASHER (SQUARE HOLE)
					2			AN970-6	* WASHER
					1			MS24665-302	* COTTER PIN
					2			MS21042L3	* NUT
					2			MS24693-C272	* SCREW
					2			MS24693-C277	* SCREW
					1			NAS1149D0663J	* WASHER (OR AN960JD616)
					11			AN3-6A	BOLT
					1			AN6-26	BOLT
					1			AN320-6	CASTELLATED NUT
					11			NAS1149D0363J	WASHER (OR AN960JD10)
					1			NAS1149D0616J	WASHER (OR AN960JD616L)
					2			NAS1515H6L	WASHER
					1			MS24665-302	COTTER PIN
					3			MS21071L3	ANCHORNUT
					8			MS21075L3	NUTPLATE
						1		D4097-041	ARMREST ASSEMBLY
						1		D3696-041	* ARM ASSEMBLY
						1		D3696-1	** ARM
						1		D3801-3	** HAND RETRACTABLE SPRING PLUNGER
					1			D4098-041	* CUSHION ASSEMBLY
					1			D4099-1	* BRACKET
					3			MS21042L3	* NUT
					5			MS24693-C273	* SCREW
					3			MS24693-C277	* SCREW
					1			NAS1149D0332J	* WASHER
					11			AN3-6A	BOLT
					1			AN6-26	BOLT
					1			AN320-6	CASTELLATED NUT
					11			NAS1149D0363J	WASHER (OR AN960JD10)
					1			NAS1149D0616J	WASHER (OR AN960JD616L)
					2			NAS1515H6L	WASHER
					1			MS24665-302	COTTER PIN
					3			MS21071L3	ANCHORNUT
					8			MS21075L3	NUTPLATE
							4	D3932-1	SNAP VENT

* DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

** DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

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Revision: E

Date: 12.12.07

Work Order ID 105405

105405

Page 1

August-01-13 11:30:30 AM

Item ID: D412-761-047

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Instrument Panel

Start Date: 8/01/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/01/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 13-08-01

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-761	E								
100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPP D412-761-047	CHG002							
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MLJ 13-11-29